

Work Order ID 86316

Wednesday, June 27, 2012 9:28:42 AM

86316

Today

Page 1

Item ID: D4170-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 6/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *12-06-27*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4170

B

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

12-06-27

4

Hardinge CNC Lathe Small

Machine as per Folio FA989

FOLIO REV:

DWG REV:

DEBURR

Manual

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12-06-27

4

Quality Control

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Page 2

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Item Name: Bushing

Stop

NS2

Start Date: 6/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

St/D.A 12/06/27

4

✓

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

CF 40 12-6-27

130

Identify as per dwg & Stock Location: *ST 104* 0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

ex. SP 12-6-27

Picklist Print

Wednesday, June 27, 2012 9:28:41 AM

Page 1

Work Order ID: 86316

Parent Item: D4170-3

Parent Item Name: Bushing

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD
revB DD verf:EC IPP Rev:A 10.11.02 as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	104.9680	0.275	1.1578947			

Location

Loc Qty

Loc Code

MAT012

104.968

114488

1.997

117379

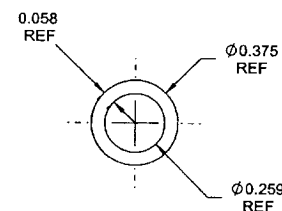
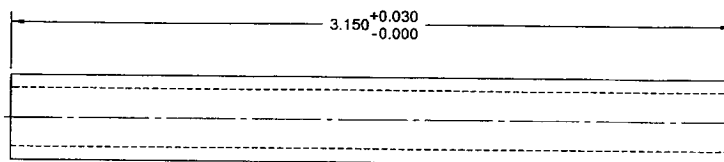
9.288

118043

93.683

1.12

12-06-27



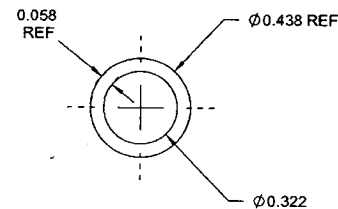
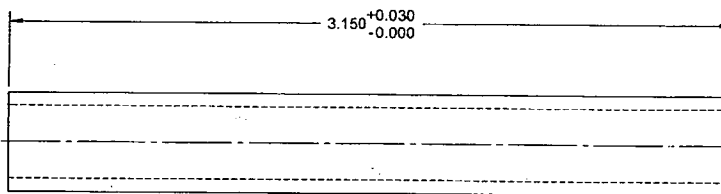
D4170-1 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, ϕ 3/8 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	93	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	10.10.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4170-3 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
OR
6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER VW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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